54611 DREV

Work Order ID 52295

Tuesday, September 22, 2009 1:57:28 PM

Item ID: D3923-1
Revision ID: A
Item Name: Angle

Start Date: 9/23/2009 **Start Qty:** 5.00
Required Date: 10/9/2009 **Req'd Qty:** 5.00
Reference:

Accept **Setup Start** **Stop**

Cust Item ID:
Customer:

Run Start **Stop**

Approvals: **Process Plan:** WK PD **Date:** 09-9-22 **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Draw Nbr	Revision Nbr
D3923	A

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100		0.00							
Waterjet	**Memo**	0.00					HB 9-11-5		
FLOW CNC Waterjet 6061 .063	1-Cut as per Dwg D3923 Dwg Rev: A Prog Rev: A ***grain direction per dwg*** 2-Deburr if necessary								(14)
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	**Memo**	0.00					HB 9-11-5		
Quality Control									

Work Order ID 52295

Tuesday, September 22, 2009 1:57:28 PM

Item ID: D3923-1
Revision ID: A
Item Name: Angle

Start Date: 9/23/2009 **Start Qty:** 5.00
Required Date: 10/9/2009 **Req'd Qty:** 5.00
Reference:

Accept **Setup Start** **Stop**

Cust Item ID:
Customer:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check **Memo**	0.00 0.00	2) Sorlulos			(14)	0		
130 Brake NC Brake NC	**Memo** 1- Bend as per Dwg	0.00 0.00	SB 09/22/10			14	0		
140 QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00	2) Sorlizlil			(14)	0		

Work Order ID 52295

Tuesday, September 22, 2009 1:57:28 PM

Item ID: D3923-1
Revision ID: A
Item Name: Angle
Start Date: 9/23/2009 **Start Qty:** 5.00
Required Date: 10/9/2009 **Req'd Qty:** 5.00
Reference:

Accept **Setup Start** **Stop**

Cust Item ID:
Customer:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 **Memo**	0.00 0.00	BR 09-12-14			(14).			
160 Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 M 109091 **Memo** POWDER COAT: Start Time: 2:45 Oven Temperature: 390° Finish Time: 3:15	0.00 0.00	BR 09-12-14			(14).			
170 QC Quality Control	QC3- Inspect Part Finish **Memo**	0.00 0.00	JH 09/12/15			(X14)	0		

Work Order ID 52295

Tuesday, September 22, 2009 1:57:28 PM

Item ID: D3923-1
Revision ID: A
Item Name: Angle

Start Date: 9/23/2009 **Start Qty:** 5.00
Required Date: 10/9/2009 **Req'd Qty:** 5.00
Reference:

Accept **Setup Start** **Stop**

Cust Item ID:
Customer:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location 135	0.00							
Packaging	**Memo**	0.00							
Packaging							09/12/17		(14)
190	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00							
Quality Control							09-12-16		(14)

Picklist Print

Tuesday, September 22, 2009 1:57:27 PM

Work Order ID: 52295

Parent Item: D3923-1RevA

Parent Item Name: Angle

Comments:

Start Date: 9/23/2009 **Required Date:** 10/9/2009

Start Qty: 5.00 **Required Qty:** 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No			100	sf	99.8958	0.4316	~~5~~ 1.	HB 9-11-5	

6061-T6 .063 Sheet

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
MAT	99.89582105	
110551	99.8958211	110551

DART AEROSPACE LTD	Work Order:	52295
Description: ANGLE	Part Number:	D3923-1
Inspection Dwg: D3923-1 Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [] Prototype

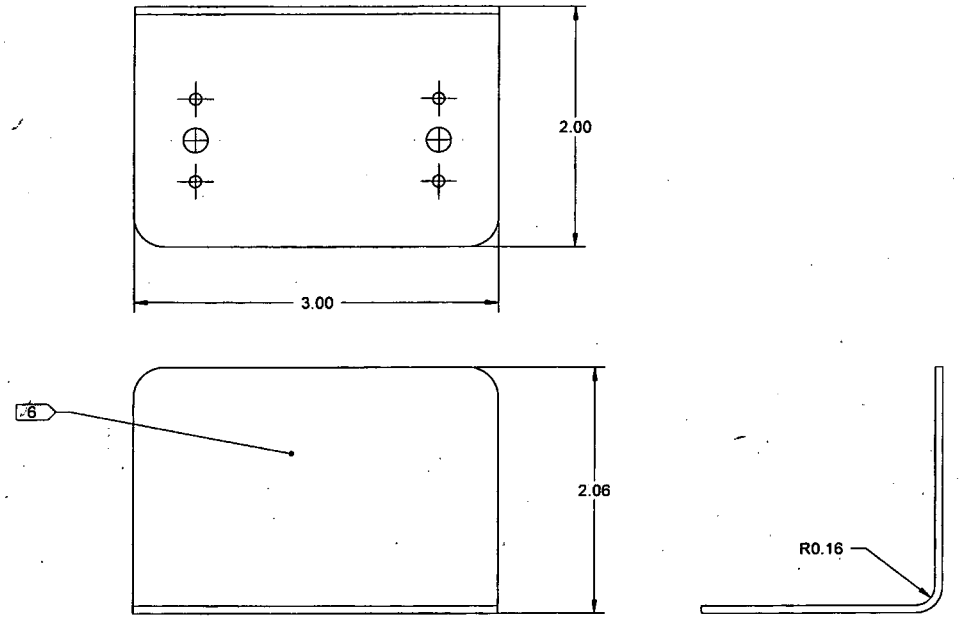
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	+.004 -.001	.099	X			
Ø .204	+.005 -.001	.208	X			
.344	+/- .010	.345	X			
.50	+/- .030	.500	X			
.50	+/- .030	.501	X			
.91	+/- .030	.910	X			
3.00	+/- .030	3.005	X			
3.93	+/- .030	3.936	X			
.063	+/- .010	.063	X			

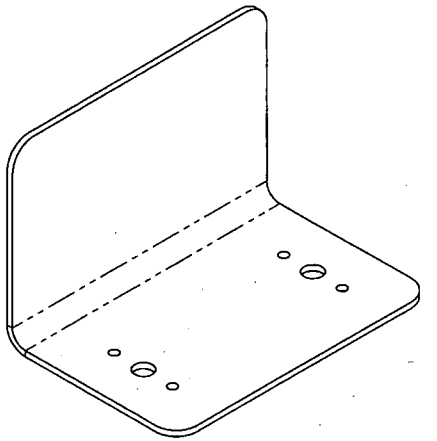
Measured by:	RB
Date:	9-11-5

Audited by:	S
Date:	09/14/05

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	





SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52295

RELEASED
2009 -08- 28

D3923-1 ANGLE
MADE FROM D3923-1F

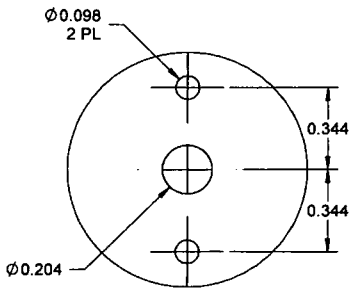
NOTES:
1) MATERIAL: MADE FROM D3923-1F
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3923-1" USING A WHITE FINE POINT PAINT MARKER
7) WEIGHT: 0.07 lbs

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE		09.03.30

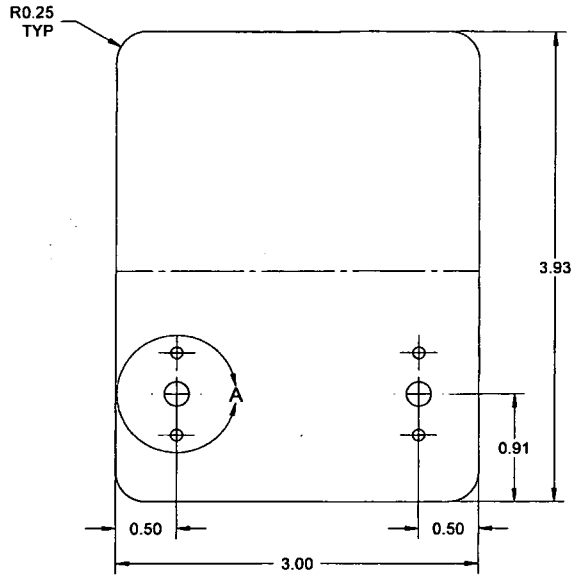
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3923	REV. A
MFG. APPR.			SHEET 1 OF 2
APPROVED		TITLE ANGLE	SCALE NTS
DE APPR.			
DATE	09.03.30		

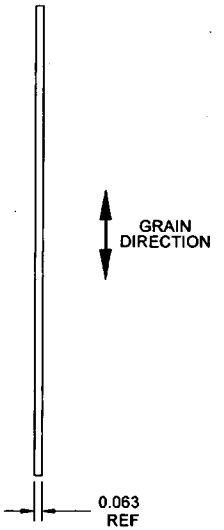
COPYRIGHT © 2009 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

52295



DETAIL A B6
TYP
SCALE 2X





D3923-1F FLAT PATTERN

RELEASED
2009 -08- 28
NAP

NOTES:
1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF DART SPEC M6061T6S.063)
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.07 lbs

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED	LSS	DRAWING NO. D3923 REV. A
MFG. APPR.		SHEET 2 OF 2
APPROVED		TITLE ANGLE SCALE NTS
DE APPR.		
DATE 09.03.30		

COPYRIGHT © 2009 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.